

Date: Monday, 22/10/2007 2:17:15 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 35296 -2
Estimate Number : 12882
P.O. Number :
This Issue : 22/10/2007 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : SMALL / MED FAB
Previous Run : 35030
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 07.05.24 EC
est rev B ECN 987 07.10.09 EC verified by: DD
Drawing Name : ARM
Part Number : D3560042
Drawing Number : D3560 UNDER REVIEW
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 29/10/2007 Qty: 14 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.4648 f(s)/Unit Total: 20.5065 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: M106182

Inf 02/11/30

(14)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 16.750" long

Inf 02/11/30

(14)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA694 Rev: 11 & Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

Inf 07/12/06

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Inf 07/12/06

J.L 02/12/07

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Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

PLATE 335331

08.02.04 5

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad)
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch (100°)
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

08.02.04 5

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/2/05 (x5042)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08.02.05 (5)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 08.02.05 (5)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.02.05

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)
Spacer *B 35330*

08/02/06 (5)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Press bushing in D3560 arm per dwg D3562

08/02/06 (5)

14.0

QC5

INSPECT WORK TO CURRENT STEP



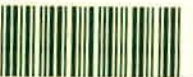
Comment: INSPECT WORK TO CURRENT STEP

08/02/06 (5)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W/H*

08.02.06

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

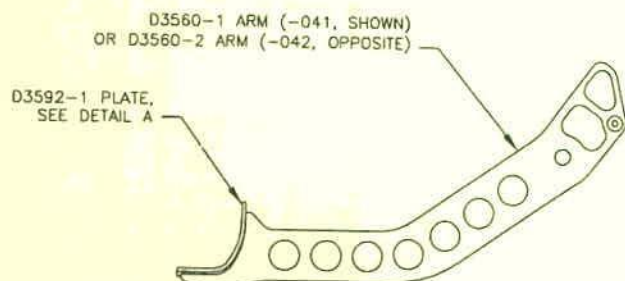
08/02/08 (5)

Job Completion

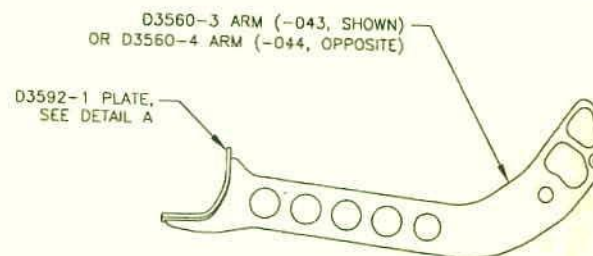


2008/2/06 (5)

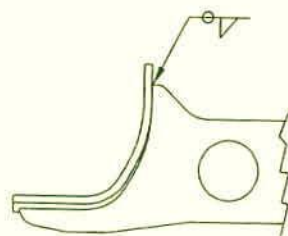
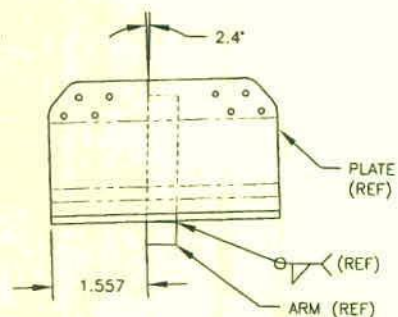
W



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

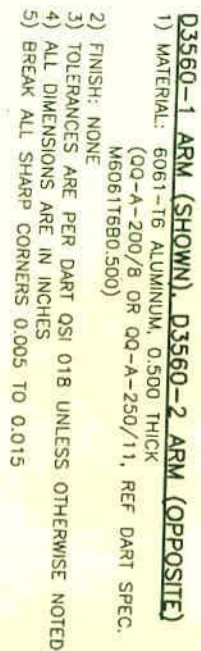
RELEASED
(07.06.19)
UNDER REVIEW
(07.10.22 DE)

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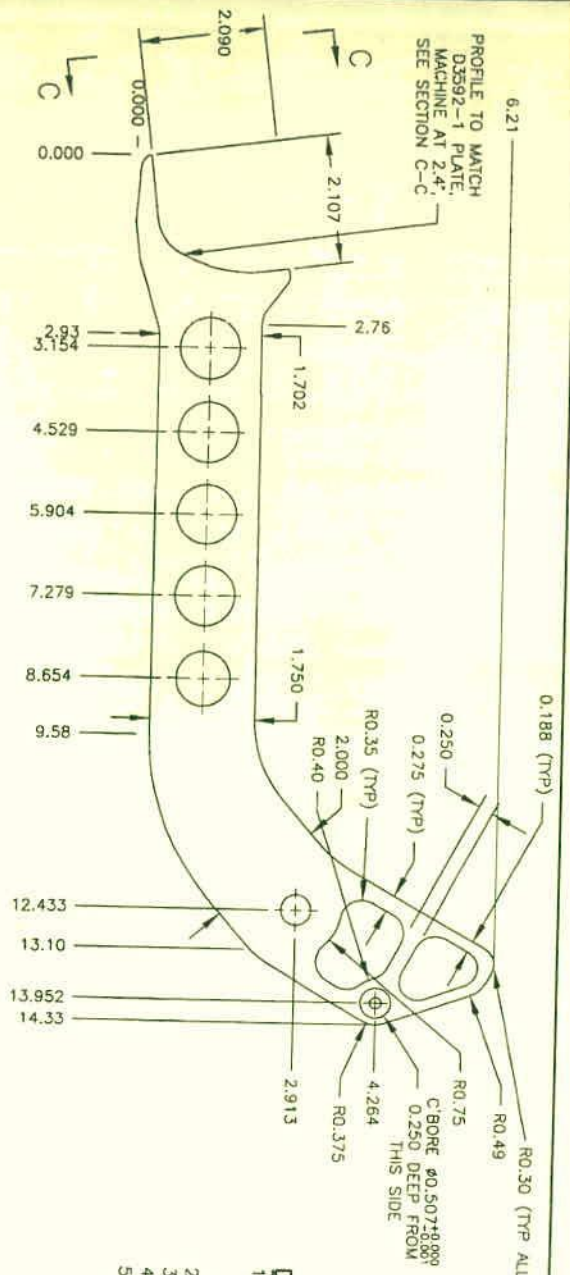
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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	qf	DRAWN BY qf
CHECKED	HT	APPROVED HT
DATE	07.06.19	TITLE
		ARM WELDMENT
		DART AEROSPACE LTD. WILLOWDALE, ONTARIO, CANADA
		DRAWING NO. D3560
		REV. C
		SHEET 3 OF 3
		SCALE 1:4

W/D 3560



DESIGN	97	DRAWN BY	97	 DART AEROSPACE LTD. <small>MANUFACTURING DIVISION, CANADA</small>
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	
DATE	07.06.19	DRAWING NO.	D3560	
		TITLE	ARM WELDMENT	
				REV. C SHEET 2 OF 3 SCALE

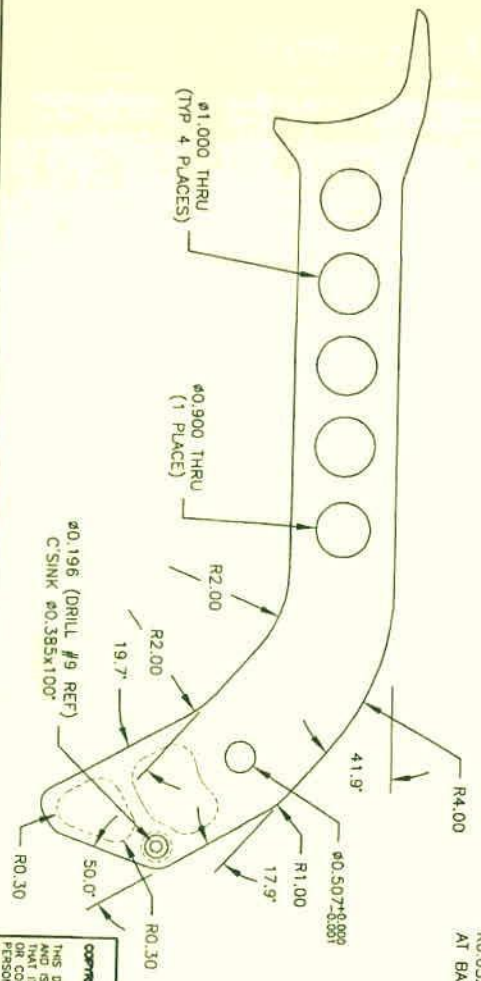
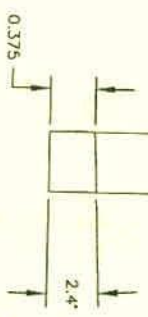


- D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)**
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK (QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

R0.13 (TYP)
(POCKETING RAD)

R0.032
AT BASE OF C'BORE

SECTION C-C
VIEW ROTATED
SCALE 1:1



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DESIGN	DATE	CHKD	APPROVED	ISSUING NO.	TITLE	SCALE
40	07.06.19			D3560	ARM WELDMENT	1:2

RELEASED
07.06.19

DART
DART AEROSPACE LTD.
HAMILTON, ONTARIO, CANADA

W/O:)		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries